

Work Order ID 91967

91967

Page 1

October-19-12 2:57:21 PM

Item ID: D350-689-017

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Shoulder Harness (4 point inertia reel)

Stop

NS2

Start Date: 10/18/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MUS

Date: 12-10-22 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-689	B

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-689-017 CHG001

0.00

DAS
16

12/10/26

J. J. MUS 12-10-25

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

12/10/24 JB

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

DAS
16

12/10/26

(C)

NCR: Yes / No

DQA: Date: ,

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain	General			Ovalized	Pressure/Forced		
Centre Not Concentric to O/S	Bend	General			Hardware	General			Over/Under tolerance	Temperature/Cure	
Cracks	BOM/Route	General			Inspection Incomplete	General			Part Incorrect	Weld	
Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear	General			Part Lost/Missing	Wrong Stock Pulled	
Cuffs	Burrs	General			Maintenance	General			Part Moved		
Heat Treat	Contamination	General			Mislabeled	General			Positioned Wrong		
Inspection Strip in Tube	Countersink	General			Misread	General			Power Loss/Surge		
Ripples in Bend	Cut Too Short	General			Offset	General					
Torque Waves in Extrusion	Drill Holes	General			Out of Calibration	General					
Turning Sequence	Drawing	General			Out of Sequence	General					
Wave/Twist in Tube	Finish	General			Outside Dimensions	General					
	Folio	General				General					

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91967

Page 2

Item ID: D350-689-017

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Shoulder Harness (4 point inertia reel)

Stop

NS2

Start Date: 10/18/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

sf

SL 12/10/26

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-689-017

Location: O43

PPP Rev:

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/10/26

MLJ 12-10-26

NCR: Yes / No

DQA: Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

Picklist Print

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Page 1

Work Order ID: 91967

Parent Item: D350-689-017

Parent Item Name: Shoulder Harness (4 point inertia reel)

Start Date: 10/18/12

Required Date: 11/09/12

Comments: IPP Rev:A new issue DD 10.04.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY									
Landing Gear				General					
Bending				Bend <input type="checkbox"/>		Grain <input type="checkbox"/>		Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric to O/S				BOM/Route <input type="checkbox"/>		Hardware <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks				Broken/Damaged <input type="checkbox"/>		Inspection Incomplete <input type="checkbox"/>		Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>
Crushed/Crimped.				Burrs <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>		Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs				Contamination <input type="checkbox"/>		Maintenance <input type="checkbox"/>		Part Moved <input type="checkbox"/>	
Heat Treat				Countersink <input type="checkbox"/>		Mislabeled <input type="checkbox"/>		Positioned Wrong <input type="checkbox"/>	
Inspection Strip in Tube				Cut Too Short <input type="checkbox"/>		Misread <input type="checkbox"/>		Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Ripples in Bend				Drill Holes <input type="checkbox"/>		Offset <input type="checkbox"/>			
Torque Waves in Extrusion				Drawing <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>			
Turning Sequence				Finish <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>			
Wave/Twist in Tube				Folio <input type="checkbox"/>		Outside Dimensions <input type="checkbox"/>			

Picklist Print

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Page 2

Work Order ID: 91967

Parent Item: D350-689-017

Parent Item Name: Shoulder Harness (4 point inertia reel)

Start Date: 10/18/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0516J
Washer

Purchased No 110 Each 201.0000

4

Location Loc Qty Loc Code

ST293 192

123352 192

ST298 9

114797 9

123352

Snd

NCR: Yes / No

DQA: _____ Date: _____ , .

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation, Fwd Position	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-kg	60.7 in 1.54 m	1675 in-lb 19.3 m-kg
D350-689-013 Floor Provisions Kit, Fwd Position	2.0 lb 0.9 kg	-18.2 in -0.46 m	-36 in-lb -0.4 m-kg	60.7 in 1.54 m	121 in-lb 1.4 m-kg
D350-689-011 Dual High Back Seat Installation, Aft Position	28.1 lb 12.7 kg	-18.2 in -0.46 m	-511 in-lb -5.8 m-kg	63.7 in 1.62 m	1790 in-lb 20.57 m-kg
D350-689-013 Floor Provisions Kit, Aft Position	3.1 lb 1.4 kg	-18.2 in -0.46 m	-56 in-lb -0.6 m-kg	62.2 in 1.58 m	193 in-lb 2.2 m-kg
D350-689-015 Seat Modification Kit	1.0 lb 0.5 kg	-17.2 in -0.44 m	-17 in-lb -0.22 m-kg	60.7 1.54 m	61 in-lb 0.77 m-kg
D350-689-017 Shoulder Harness, Fwd Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	60.7 in 1.54 m	267 in-lb 3.08 m-kg
D350-689-017 Shoulder Harness, Aft Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	64.7 in 1.64 m	285 in-lb 3.28 m-kg
D350-689-019 Control Guard, Fwd Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	60.7 in 1.54 m	30 in-lb 0.35 m-kg
D350-689-019 Control Guard, Aft Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	64.7 in 1.64 m	32 in-lb 0.38 m-kg
D350-689-021 Dual High Seat Back Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	60.7 in 1.54 m	1772 in-lb 20.3 m-kg
D350-689-021 Dual High Seat Back Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	64.7 in 1.64 m	1889 in-lb 21.6 m-kg
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-kg	62.2 in 1.58 m	156 in-lb 1.7 m-kg

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
						X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
								X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
									D3016-041	SEAT FRAME ASSEMBLY
									D3017-041	BACK FRAME ASSEMBLY
1									D3018-1	SEAT CUSHION
1									D3019-1	BACK CUSHION
									D3021-041	TUBE ASSEMBLY
									D3022-1	SEAT PAN
									D3023-1	BACK PANEL
									D3024-1	SPACER
1									D3025-1	BEAM

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
1						1			D3026-1	CHANNEL
1									D3027-1	CLIP
1									D3027-3	CLIP
1									D3027-5	CLIP
4						4			D3027-7	CLIP
							4		D3028-1	STUD
			2				2		D3029-1	SPRING
			2				2		D3030-1	LOCK
							2	2	D3031-1	LOOP
1									D3032-1	SPACER
2	1								D3033-1	SEAT TRACK
			4						D3059-1	STUD
			4						D3060-1	BUSHING
			4						D3061-1	RADIUS BLOCK
				1					D3084-3	STRUT
1									D3234-1	DOUBLER
1					1				D3234-3	DOUBLER
2							2		D3234-5	SPACER
							4		D3808-041	SEAT RAIL ASSEMBLY
							1		D3809-1	SLIDING BLOCK
								1	D3811-041	SEAT TRACK ASSEMBLY
			2						D4071-041	SHOULDER HARDNESS ASSY
						3	3		AN3-12A	BOLT
				1					AN4-12A	BOLT
				1					AN4-20A	BOLT
			2						AN5-4A	BOLT
						40	40		MS20600AD4W2	RIVET
						6	6		MS20600AD4W3	RIVET
						9	17	17	MS21042L3	NUT (OR MS21042-3)
							6	6	MS21042L4	NUT (OR MS21042-4)
	4	2							MS21042L5	NUT (OR MS21042-5)
12	4								MS21059L3	NUTPLATE
						4	4		MS24693-S272	SCREW
2	1								MS24693-S273	SCREW
							8		MS24694-S3	SCREW
							9		MS24694-S50	SCREW
								4	MS24694-S148	SCREW
6	3								MS27039-1-10	SCREW
								4	MS27039-1-17	SCREW
								6	MS27039-1-19	SCREW
								6	MS27039-4-21	SCREW
6	3						17	17	NAS1149D033J	WASHER (OR AN960JD10L)
							9		NAS1149D036J	WASHER (OR AN960JD10)
			8						NAS1149D0416J	WASHER (OR AN960JD416L)
								6	NAS1149D0432J	WASHER (OR AN960JD416)
	4								NAS1149D0516J	WASHER (OR AN960JD516L)
								4	NAS1149D0563J	WASHER (OR AN960JD516)
							2		NAS43DD4-46N	SPACER

